

# Work Order ID 50880

July 23, 2009 10:14:06 AM

Page 1

Item ID: D212-664-207TRN

Accept

Revision ID: A

Item Name: Crosstube Turning Detail

Start Date: 7/28/2009 Start Qty: 1.00

Required Date: 7/31/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D212-664-247

Rev A

100

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA706: 2-Turn first side as per Folio FA706: 3- File transition lines smooth.

A.m 09 - 08 - 20 ①

110

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

A.m 09 - 08 - 20 ①

120

0.00



Mori Seiki

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA706: 2- File transition lines smooth. 3- Remove sand and plugs

A.m 09 - 08 - 20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 50880**

July 23, 2009 10:14:06 AM



Page 2

Item ID: D212-664-207TRN

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/28/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

A.M. 09-08-20 ①

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

① Ø - AUM 7-8-24

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

① Ø - AUM 7-8-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Work Order ID 50880

July 23, 2009 10:14:06 AM



Page 3

Item ID: D212-664-207TRN

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Turning Detail

Start Date: 7/28/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 7/31/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

①

0

BE 090824

170



Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and stock in kanban rack Location: X-TUBE CELL

①

0

- AMP-8-24

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/25 AJ

MF 09-08-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 23, 2009 10:14:05 AM

Work Order ID: 50880

Parent Item: D212-664-207TRNRevA

Parent Item Name: Crosstube Turning Detail

Comments:

Start Date: 7/28/2009

Required Date: 7/31/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6008-132RevA		Manufactured	No			110	Each	19.0000	1.0000			



Crosstube extrusion

Q-n 09.08.20

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

LG

19

38340

19

1

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	58880
<b>Description:</b> Crosstube Assembly (205/212 Low Aft)	<b>Part Number:</b>	D212-664-247
<b>Inspection Dwg:</b> D212-664-247 Rev: A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.438	+/-0.010	0.438	✓			
	2.680	+0.005/-0.000	2.680	✓			
	2.680	+0.005/-0.000	2.680	✓			
	2.687	+0.005/-0.000	2.687	✓			
	2.802	+0.005/-0.000	2.802	✓			
	2.906	+0.005/-0.000	2.906	✓			
	3.009	+0.005/-0.000	3.010	✓			
	3.112	+0.005/-0.000	3.112	✓			
	3.250	+0.005/-0.000	3.250	✓			
SIDE B	0.438	+/-0.010	0.438	✓			
	2.680	+0.005/-0.000	2.680	✓			
	2.680	+0.005/-0.000	2.680	✓			
	2.687	+0.005/-0.000	2.687	✓			
	2.802	+0.005/-0.000	2.802	✓			
	2.906	+0.005/-0.000	2.906	✓			
	3.009	+0.005/-0.000	3.010	✓			
	3.112	+0.005/-0.000	3.112	✓			
	3.250	+0.005/-0.000	3.250	✓			
	128.27	+/-0.030	128.300	✓			

<b>Measured by:</b>	G.M	<b>Audited by:</b>	ALM	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09-08-24	<b>Date:</b>	9-8-24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.07	New Issue (P/O D212-664-207)	KJ/EC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

**PARTS LIST:**

Qty	Part Number	Description
X	D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
1	D6008-132	CROSSTUBE
2	D2940-1	SUPPORT
4	D3595-063-530	RUBBER CUSHION
2	D3660-1	CUFF
4	MS21920-28	CLAMP (OR MS21920-30)
44	CR3212-4-06	RIVET (OR M7885/3-4-06)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6008-132  
FINISHED LENGTH = 128.27 ± 0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE.
- 6) WHEN MACHINING TAPER, RUN-OFF PART AT STOCK. BLEND OUT EDGE LONGITUDINALLY.  
TRANSITION SHOULD BE SMOOTH.
- 7) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE  
TO BENDING IS 8% BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 8) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 9) SCRIBE DART PART NUMBER AND BATCH NUMBER ON INNER SURFACE OF TUBE WITH A  
VIBRATING STYLUS.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1  
THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE  
D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN.-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY  
AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 14) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A  
LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN  
CUFF AND CROSSTUBE. SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 15) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

*Handwritten:* 55880

**DEO ATTACHED  
RELEASED**  
07.07.07

A		07.07.07	NEW ISSUE
DESIGN	<i>qp</i>	DRAWN BY	<i>qp</i>
CHECKED		APPROVED	<i>qp</i>
DATE		07.07.07	
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		REV. A	SHEET 1 OF 3
		SCALE	NTS

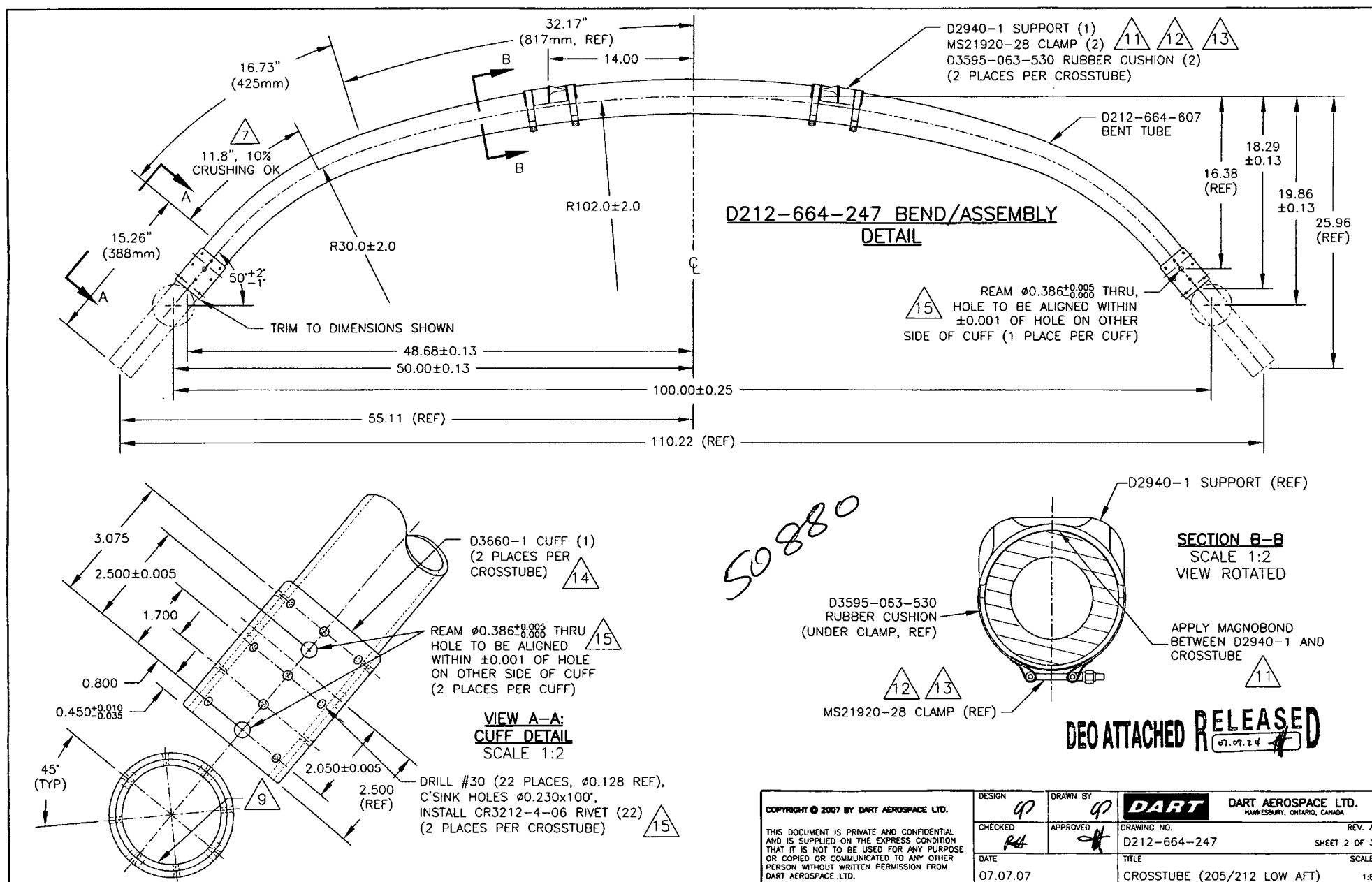
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



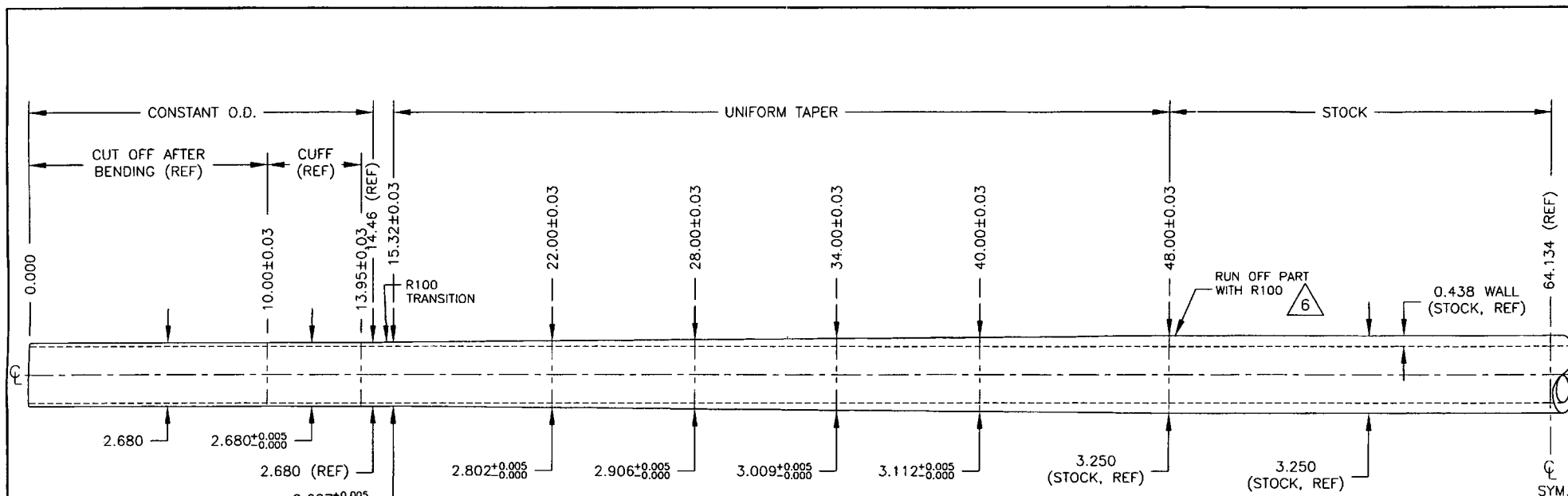
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D212-664-247 MACHINING DETAIL

RELEASED  
07.04.24  
DEO ATTACHED

50880

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED <i>qp</i>	APPROVED <i>qp</i>	DRAWING NO. D212-664-247	REV. A SHEET 3 OF 3
DATE 07.07.07		TITLE CROSSTUBE (205/212 LOW AFT)		SCALE 1:4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DRAWING NO. D212-664-247	TITLE CROSSTUBE	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D212-664-247-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>RY</i>	MFG. APPR. <i>AA</i>	APPROVED <i>AM</i>		DE APPR. <i>HH</i>		
DATE 09.05.01	DATE 09.06.15	DATE 09/06/22	DATE 09/06/22		DATE 09.06.22		

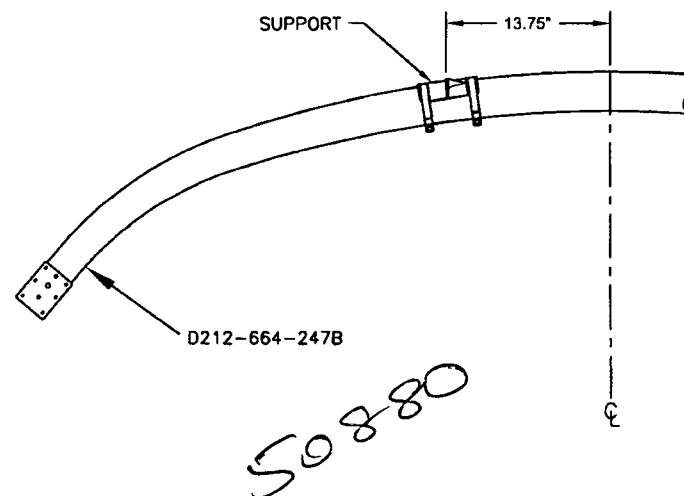
**CHANGE:**

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)

THE D212-664-247B CROSSTUBE HAS THE SAME PARTS LIST AS THE D212-664-247 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D212-664-247 CROSSTUBE.

**RELEASED**  
09/06/22



**FIGURE 1 - SUPPORT INSTALLATION**

W/O:		WORK ORDER CHANGES					
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